

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000397**Date Inspected:** 28-Aug-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** (BV) Xu Liang Zhang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** 77 Mock-Up**Summary of Items Observed:**

Item: Skin Plate-A of the 77 Mock-Up was in position and the root weld of stiffener plate MP 2-2 had previously been back gouged and the final grinding was being performed. The ZPMC QA that was present was Ken Zhang. Both the CWI and the QA were made aware that further grinding was necessary for the root areas preparation. Areas of concern were marked with a soap stone and the CWI and QA made aware of there locations. It was explained that there should be no sharp edges, pitting or deep indention's within the beveled area prior to welding. There was a minor problem with the depth of the beveled area being about the same depth or slightly deeper than that of the width of the grinding disk. Once the grinding has been completed cleaning to bare metal with a power wire brush should follow. As stated by the QA grinding would continue for a short time but would be completed during the following shift.

**Summary of Conversations:****Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

**Inspected By:** Smith,David

Quality Assurance Inspector

**Reviewed By:** McClary,David

QA Reviewer